

Work Order ID 68717

Wednesday, April 20, 2011 10:20:13 AM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 4/20/2011

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11/6/12 *[Signature]*

11/06/03 *[Signature]*

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4030-041

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Setup Start



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Stop



Item Name: Long Basket Assembly (350)

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 68716

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ME
11-06-03

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 20, 2011 10:20:19 AM

Page 1

Work Order ID: 68717

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)





Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	10.0000	1				
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST506			10						
				66171			2						
				66563			8						
D2535  Spring		Manufactured	No			100	Each	59.0000	2				
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504			59						
				64280			5						
				66764			54						
D2537  Bushing		Manufactured	No			100	Each	52.0000	2				
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504			52						
				65077			10						
				66972			42						
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1				
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			1						

B68718 (10)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 68717



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3914-041 Manufactured No



Long Basket Lid Assembly (350)

D3917-3 Manufactured No



Washer

100 Each 0.0000 1

B68719



1 11/06/03

100 Each 36.0000 6



B69513

Location Loc Qty Loc Code

ST091 34

67780 34

ST092 2

66903 2

D3953-3 Manufactured No



Gas Spring Stud, Lid

100 Each 16.0000 2



2 B69611

Location Loc Qty Loc Code

ST096 16

68230 16

D3953-7 Manufactured No



Spring Spacer

100 Each 33.0000 2



2

Location Loc Qty Loc Code

ST096 33

65053 4

68464 29

D3953-9 Manufactured No



Gas Spring Washer

100 Each 16.0000 2



2 B69625 11/6/2

Location Loc Qty Loc Code

ST096 16

68231 16

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Parent Item Name: Long Basket Assembly (350)

Start Date: 4/20/2011



Required Date: 4/25/2011

Start Qty: 1.00



Required Qty: 1.00

D3953-17	Manufactured	No	100	Each	22.0000	2	2
							B69603 sf
Gas Spring Spacer							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	22	
67968	22	

D3953-19	Manufactured	No	100	Each	6.0000	1	1
							B68462 sf
Gas Spring Bracket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	6	
59213	1	
64810	5	

D3953-21	Manufactured	No	100	Each	5.0000	1	1
							B68463 sf
Gas Spring Bracket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	5	
66110	5	

D3969-3	Manufactured	No	100	Each	1.0000	1	1
							B68925 sf
Spring (Basket Lid)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST272	1	
64285	1	

AN3-14A	Purchased	No	100	Each	11.0000	4	4
							M117513 11/6/2 sf
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	11	
116978	11	

Wednesday, April 20, 2011 10:20:20 AM

Shop Packet Print

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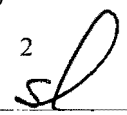
Parent Item Name: Long Basket Assembly (350)

Start Date: 4/20/2011



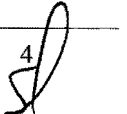
Required Date: 4/25/2011

Start Qty: 1.00



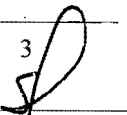
Required Qty: 1.00

AN3-16A	Purchased	No	100	Each	167.0000	2	2
							
Bolt							



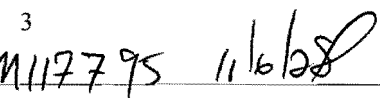
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	167	
114752	17	
116419	50	
<u>117441</u>	100	

AN5-17A	Purchased	No	100	Each	96.0000	4	4
							
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	96	
116590	66	
<u>117313</u>	30	

AN4-12	Purchased	No	100	Each	32.0000	3	3
							
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	32	
<u>116786</u>	32	

AN310-4	Purchased	No	100	Each	49.0000	3	3
							
NUT							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST324	49	
117442	49	

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Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

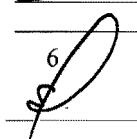
Required Qty: 1.00



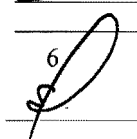
AN310C4	Purchased	No	100	Each	75.0000	2	2
							
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST324	75	
116741	25	
117395	50	

2

6

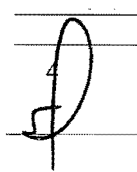




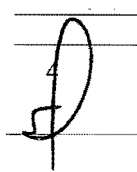
MS21042L3	Purchased	No	100	Each	2,500.000	6	6
							
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2500	
116391	126	
116540	800	
116549	774	
117441	800	

6

4

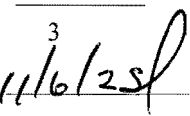




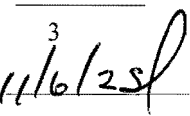
MS21042L5	Purchased	No	100	Each	1,226.000	4	4
							
Nut							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1226	
116105	466	
116548	260	
117441	500	

4

3



MS24665-151	Purchased	No	100	Each	505.0000	3	3
							
Cotter Pin							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST309	505	
17566	505	

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, April 20, 2011 10:20:21 AM

Work Order ID: 68717

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

92.0000

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

92

116823

92

NAS1149F0432P

Purchased

No

100

Each

730.0000

6



Washer

Location

Loc Qty

Loc Code

ST275

730

117291

730

NAS1149F0563P

Purchased

No

100

Each

72.0000

4



Washer

Location

Loc Qty

Loc Code

ST275

72

114576

72

NAS1149F0332P

Purchased

No

100

Each

184.0000

8



WASHER

Location

Loc Qty

Loc Code

ST275

184

17317

184

NAS1149C0432R

Purchased

No

100

Each

6,492.000

2



Washer

Location

Loc Qty

Loc Code

ST297

6492

116900

1492

117291

5000

Wednesday, April 20, 2011 10:20:21 AM

Shop Packet Print

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

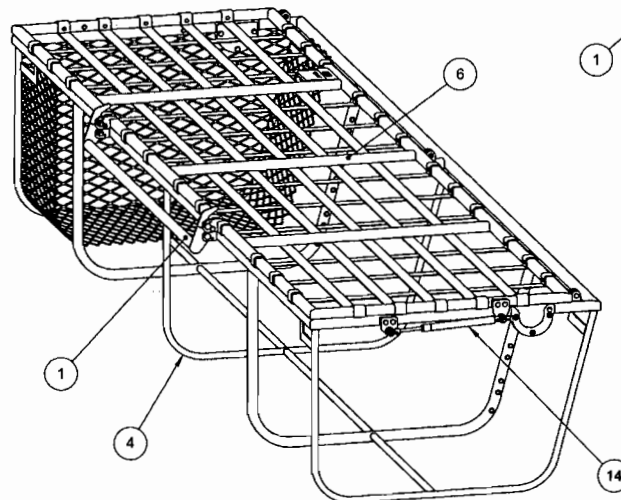
WITHOUT NOTICE

WORK ORDER

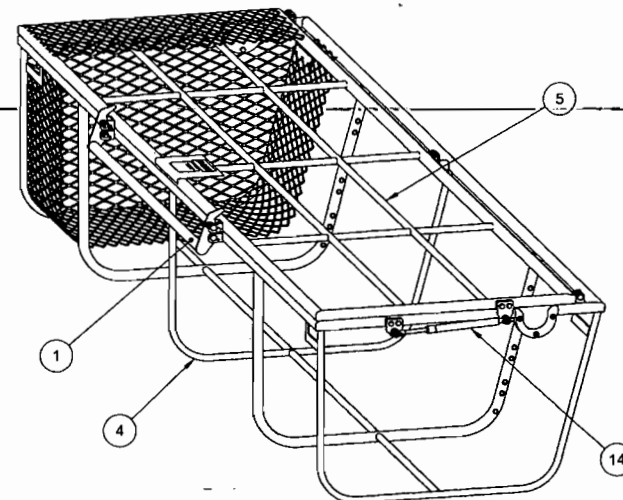
NO. 68717

BS11-01-20

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12
ECN 10-596

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED. AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JP		
CHECKED	JFS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 TITLE LONG BASKET ASSY (350) COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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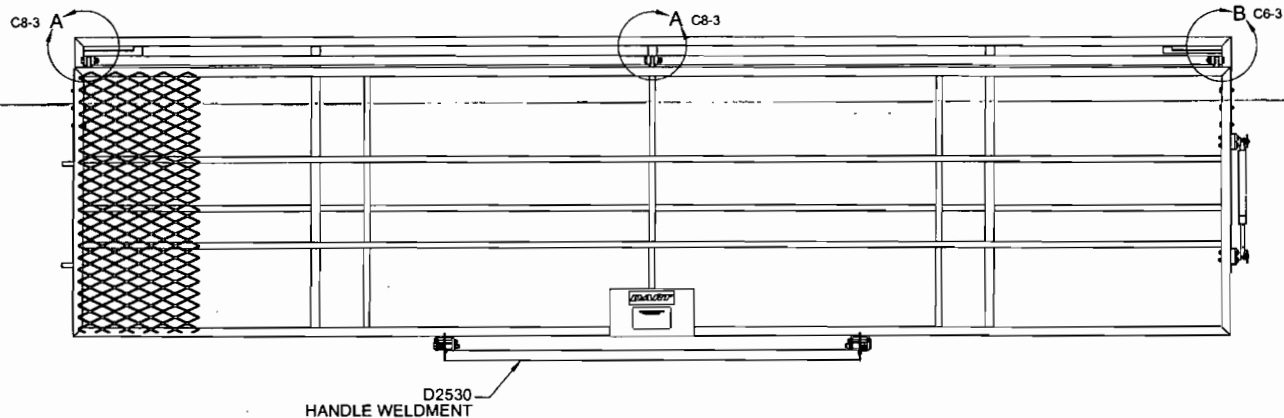
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

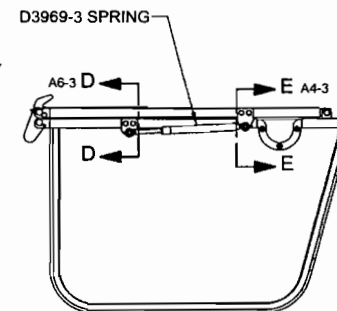
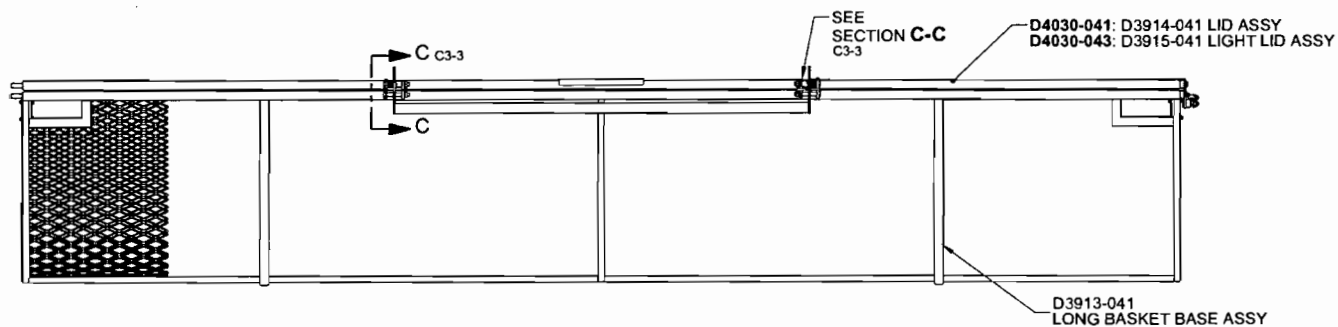
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W/0 65717



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	SFS	D4030	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET ASSY (350) _ _ _ NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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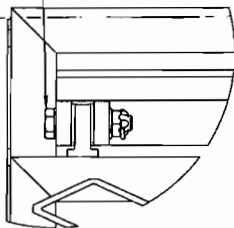
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

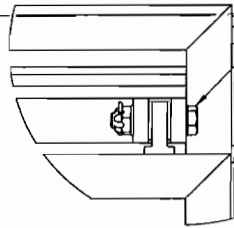
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



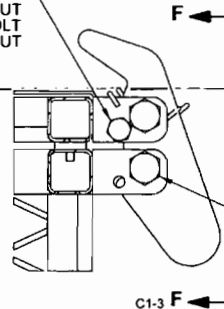
DETAIL A D8-2
D5-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

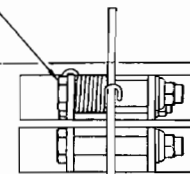


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

u6 68712

RELEASED
10.08.12

DESIGN	415	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S. BIL	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries